Work Order Monday, December											Page 1
	3622-11			Accept				iii s	etup Sta	rt	
Revision ID: Item Name: Ba	all Stud							:	Sto		
	2/6/2010 2/13/2010	Start Qty: 12.00 Req'd Qty: 12.00		,	Cust Item I	ID:					
Reference:							- m	TC	lun Sta	rt 	18318 186 1881 1881
Approvals: F	Process Pla	in: MF	Date: 10-12-06	Tooling:	D	ate:		1			
(QC:		Date:	SPC (Y/N):	D	ate:			Sto	Р	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3622	С										
		Hardinge CNC LATHI	E SMALL	0.00				12	d)		
Hardinge Hardinge CNC Lathe S	Small	FOLIO RI DWG RE	AS PER FOLIO F969 & DWG EV: V: RR AS REQUIRED								
			21/	10/12/21							
110		QC2- Inspect parts off	machine FAI/FAIB	0.00					/	^	
QC		Memo	: :	0.00				12	Ø.		
Quality Control			12	10/12/21	,					÷	
120		QC8- Inspect parts - so	econd check	0.00	_			12			
QC		Memo		0.00	16.12	- 2/					

Quality Control

Dart Aerospace Ltd

W/O:		· · · · · · · · · · · · · · · · · · ·	WC	RK ORDER CHANGE	<u> </u>						
DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector		
								Prod Mgr	QC Inspector		
						İ					
				•							
						l					
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	:	Date:			
	Re	esolution:	Disposition	າ:	QA: N/C Clo	QA: N/C Closed: Date:					
NCR:			WORK ORDI	R NON-CONFORMA	NCE (NCR)					
DATE	0750	Description of NC		n B	Verifica	ation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio			QC Inspector		
				•							
						·					
						1					

NOTE: Date & initial all entries

Work Order ID 64460

Monday, December 06, 2010 10:22:59 AM



Page 2

Item ID:

D3622-11

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Ball Stud

12/6/2010

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Set Up/

Run Hours

Date:

Tool # Plan

Code

Start

Stop



Required Date: 12/13/2010

QC:

Date: _____

SPC (Y/N):

Date:

Stop

Reject

Number

Reject

Qty

Insp.

Stamp

Sequence ID/

Work Center ID

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location: ()

Memo

0.00

0.00

Accept

Qty

Run

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 10/12/22 10/12-22 (12)

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGE	ES								
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		PAR #:											
Resolution:			Disposition);	QA: N/C	Closed: _		Date: _					
NCR:	. <u></u>		WORK ORDE	R NON-CONFORMA	NCE (NC	R)							
11011.					•	,							
	OTED			Corrective Action Section	on B	Verif	ication	Approval	Approval				
DATE	STEP	Description of NC Section A		1.0	•	& Verif	ication tion C	Approval Chief Eng	Approval QC Inspector				
	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	& Verif			Approval QC Inspector				
	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	& Verif			Approval QC Inspector				
	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	& Verif			Approval QC Inspector				
	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	& Verif			Approval QC Inspector				
	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	& Verif			Approval QC Inspector				
	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	& Verif			Approval QC Inspector				
	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	& Verif			Approval QC Inspector				

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:23:02 AM

Work Order ID: 64460

Parent Item:

D3622-11

Parent item Name: Ball Stud



Start Date: 12/6/20: 3

Required Date: 12/13/2016

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

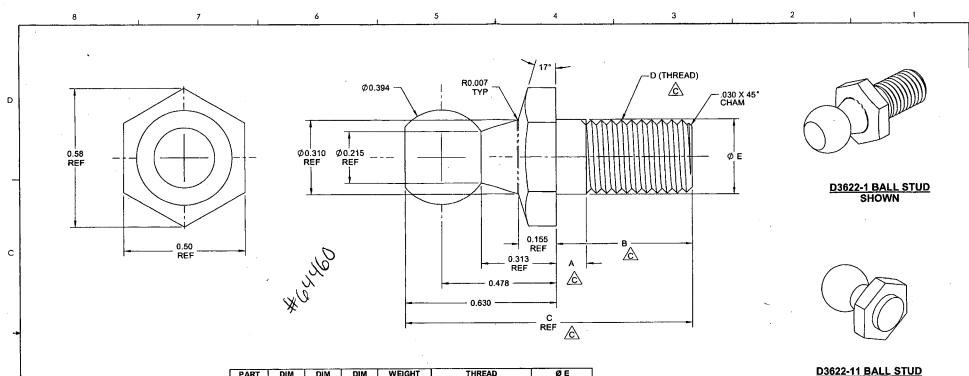
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	121.3480	0.108	1.364211	10,	1/2/	21
				Location	1	Loc	<u>Oty</u>	Loc Code					

MAT037 121.348 109778 99.548 109846 21.8

Dart Aerospace Ltd

	•									
W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,.,						
						ļ				
Part No	•	PAR #:	Fault Categ	ory:	NCR:	Yes N	lo DQ	A:	Date:	
	Res	olution:	Disposition	I	QA: N	VC Clo	sed:		Date: _	
NCR:				R NON-CONFORM						
DATE	OTED	Description of NC	Corrective Action Section E			<u> </u>	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect		Chief Eng	QC Inspector
						•				
				-1						
										,

NOTE: Date & initial all entries



	PART	DIM	DIM	DIM	WEIGHT	THREAD	Ø	E
1	NUMBER	Α	В	С	(LBS)	_D	MIN	MAX
ĺ	D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
	D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
	D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
	D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
	D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
ę	D3622-11	0.060	N/A	0.69	- 0.02	NOT THREADED	0.270	0.300
1	D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

D3622-11 BALL STUD SHOWN

C	SHEET	1: ADD - 2 DELET	5, -7, ED	-9, -11 & -13. ADD D3622-X TABLE.	JPH 10.07.20			
В	ADD -3	(SHEET 2	2)		HS 09.09.18			
Α	NEW IS	SUE		MB	07.04.13			
REV.				BY	DATE			
DESIG	N	JP	Н	DART AEROSP	SPACE ITD			
DRAW	DRAWN JPH HAWKESBURY, ONT							
CHECH	KED		<u>.</u>	DRAWING NO.		REV. C		
MFG. APPR.		75/	D3622		SHEET 1 OF 1			

APPROVED TITLE SCALE **BALL STUD** NTS DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DODARDH IS PRIVATE AND CONFERNIAL AND IS SEPRED ON THE EXPRESS CONCIN NOT TO BE USED FOR ANY PAPPORE OR COMED OR COMANICATED TO ANY OTHER PRISO WITTON PERMISSION PROJUDENT APROPORED. 10.07.20

NOTES: 1) MATERIAL: AISI 303 HEX BAR REF DART SPEC M303H0.500

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
7) WEIGHT: SEE D3622-X TABLE

4

3

5

2

DART AEROSPACE LTD	Work Order: 64460
Description:	Part Number: 1 3623-11
Inspection Dwg:\3622 Rev:	Page 1 of 1

	FIRST	ARTICLE IN	SPECTIO	N CHE	CKLIST		
	X	First Artic	le _	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		ments
0.394	± .010 ±	0.394			MIC		
0,215	+ -010	1.214					
0.310	\$ 010	0.310					
240 - 300	NJA	-289		7			
-060	-010	.060					
.69	1.030	.691					
-630	010	635					
Master	Soft of the second			<u>.</u>	ļ		
.58	= 030	571	1				
-50	= 030	-500		 			
				<u> </u>			
				-			
							
				-			
				 			
				-	 		
			1				
				<u> </u>			
Measured by:	1>	Audited by:	in)		Prototype	Approval:	N/A
Date:	10/12/21		10-12	21		Date:	N/A
Rev Date	Change					Revised by	Approved
Α	New Issue					KJ/JLM	

H:\FORMS\Quality	y Assurance\approved	QA\FAI revD
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